Work Order ID 70407

PRELIMINARY ISSUE

Tuesday, June 07, 2011 12:46:23 PM

Item ID: D4406-043 **Accept** **Setup Start**

Revision ID: PRELIM **Stop**

Item Name: Aft Wearplate Assembly

Start Date: 6/7/2011 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 6/10/2011 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 11-06-7 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4406	PA2								
100		0.00							
Waterjet	**Memo**	0.00				BL 11-6-7			
FLOW CNC Waterjet	1-Cut as per dwg D4406								
304.050	prog rev: PA2								
	dwg rev: PA2								
	2-Deburr if required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				BL 11-6-7			
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 70407

Tuesday, June 07, 2011 12:46:23 PM

Item ID: D4406-043 **Accept** **Setup Start** **Stop**

Revision ID: PRELIM

Item Name: Aft Wearplate Assembly

Start Date: 6/7/2011 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 6/10/2011 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				42			
130 Small Fab Small Fab	**Memo** Form as per dwg D4406	0.00 0.00							
140 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00							

11/06/08 Inspected to AS2 Dwg only

11/06/08

inspector to AS2 Dwg only

11/06/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 70407

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Item Name: Aft Wearplate Assembly

Start Date: 6/7/2011 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 6/10/2011 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00				x2		11-06-15	JBL/QA
Large Fab	**Memo**	0.00							
Large Fab	weld wearplate as per dwg D4406 M117607-2059B M10705J-316								
160	QC10- Inspect visual per QSI004- ground welds	0.00				QPC 11.06.16			
QC	**Memo**	0.00							
Quality Control									
170		0.00				RT		11-06-16	(x2)
Small Fab	**Memo**	0.00							
Small Fab	Apply coating as per dwg D4406								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 70407

Tuesday, June 07, 2011 12:46:23 PM

Item ID: D4406-043 **Accept** **Setup Start** **Stop**

Revision ID: PRELIM

Item Name: Aft Wearplate Assembly

Start Date: 6/7/2011 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 6/10/2011 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00				M	11	06	16 (2)
QC	**Memo**	0.00							
Quality Control									
190	Identify as per dwg & Stock Location:_____	ENG 0.00							
Packaging	**Memo**	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

RD2385

11.07.12

POSITIVE RECALL
EFFECTIVE 11.06.20 AUTH
RELEASED _____ DATE _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 07, 2011 12:46:29 PM

Work Order ID: 70407

Parent Item: D4406-043

Parent Item Name: Aft Wearplate Assembly

Start Date: 6/7/2011 **Required Date:** 6/10/2011

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev A 11.06.06new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	158.9000	3.21	6.757895			
304/316 .050 Sheet											BII-6-7		
				Location		**Loc Qty**		**Loc Code**					
				MAT020		158.9							
					112178	3.4							
					113062	18							
					116604	1.5							
					116979	69							
					117653	67					11763		
D4407-3		Manufactured	No			150	Each	0.0000	1	2			
Bar											EL 11-6-15		

70409x8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 70407
Description: AFT WEBPLATE ASSEMBLY	Part Number: D4406-043
Inspection Dwg: D4406-3 Rev: PA2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.30	+/- .030	.303	L		V IB02	
.532 ~~.566~~	+/- .010	.531	X		V	
.88	+/- .030	.88	J		V	
.13	+/- .030	.130	X		V	
.31	+/- .030	.31	X		V	
7.86	+/- .030	7.803	J		V	
6.672	+/- .010	6.666	X		V	
1.45	+/- .030	1.45	X		V	
3.63	+/- .030	3.622	X		V	
7.00	+/- .030	7.004	X		V	
25.00	+/- .030	25.00	X		T IB01	
57.30	+/- .030	57.30	X		T	
7.72	+/- .030	7.721	X		V	
6.592	+/- .010	6.590	X		V	
2.43	+/- .030	2.436	X		V	
6.936	+/- .010	6.936	X		V	
8.07	+/- .030	8.066	L		T	
~~25~~00	+/- .030	25.00	X		T	
44.105	+/- .010	44.105	X		T	
53.63	+/- .030	53.63	X		T	
Ø .188	+.005 - .001	.192	X		V	
.050	+/- .010	.047	X		V	

Measured by:	B
Date:	11-6-7

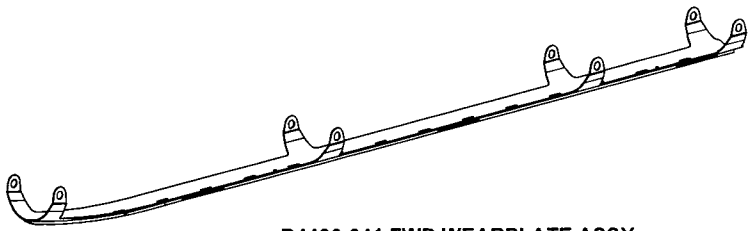
Audited by:	D
Date:	11/06/08

to PA2 Dynasty

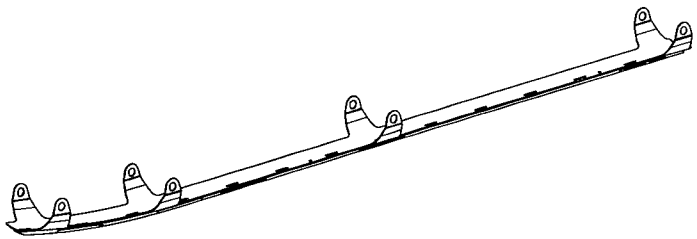
Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1			PLATE
4		1	D4406-3	PLATE
5	1		D4407-1	BAR
6		1	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2 & 3)



D4406-041 FWD WEARPLATE ASSY



D4406-043 AFT WEARPLATE ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70407
11-06-7

PRELIMINARY ISSUE

RF 11.05.27

REV.	DESCRIPTION	BY	DATE
PA2	NEW ISSUE	RF	11.05.27

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4406	REV. PA2
MFG. APPR.			SHEET 1 OF 6
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.			
DATE	11.05.27		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

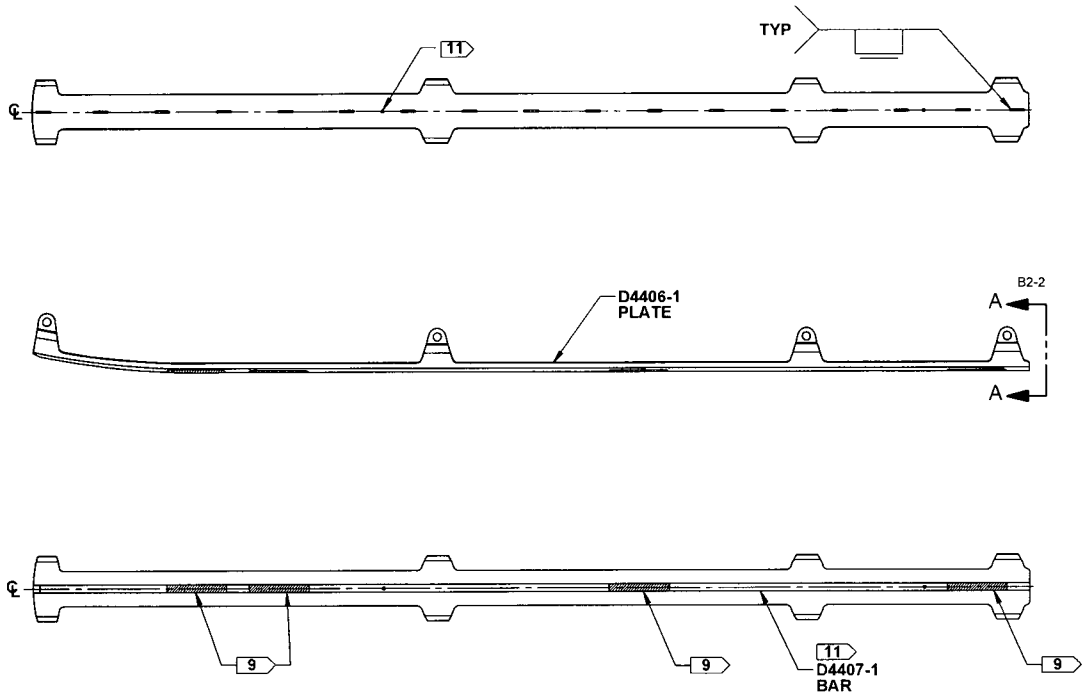
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

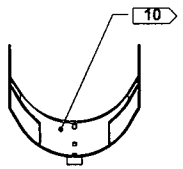
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

w/o 70407



D4406-041 FWD WEARPLATE ASSY



C3-2 **SECTION A-A**
SCALE 2X

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 5.12 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON ALL 3 SURFACES
10) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING

PRELIMINARY ISSUE

11.05.27

DESIGN	RF	**DART AEROSPACE LTD**
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4406 REV. PA2
MFG. APPR.		SHEET 2 OF 6
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
DATE	11.05.27	

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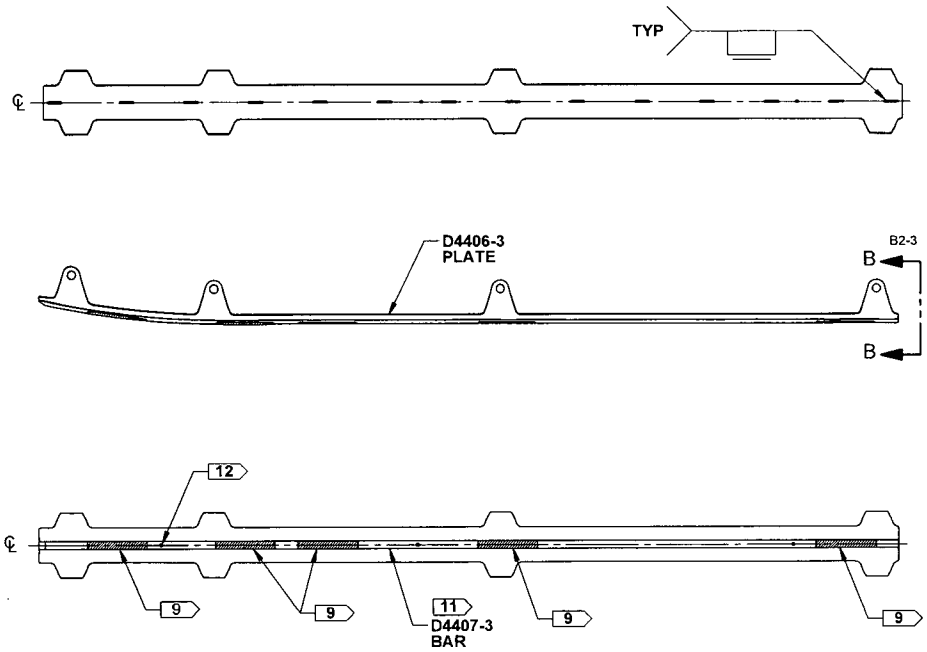
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

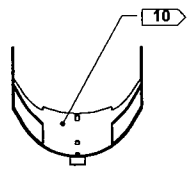
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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



u/070407

D4406-043 AFT WEARPLATE ASSY



C3-3 **SECTION B-B**
SCALE 2X

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 4.51 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON ALL 3 SURFACES
10) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY

PRELIMINARY ISSUE

RF 11.05.27

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D4406 REV. PA2 SHEET 3 OF 6
MFG. APPR.		
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
DATE	11.05.27	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

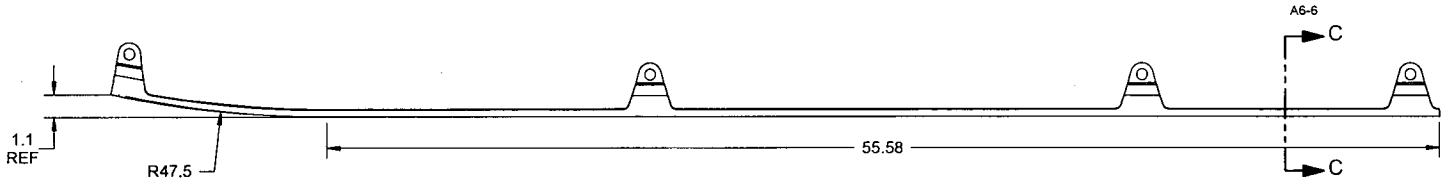
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

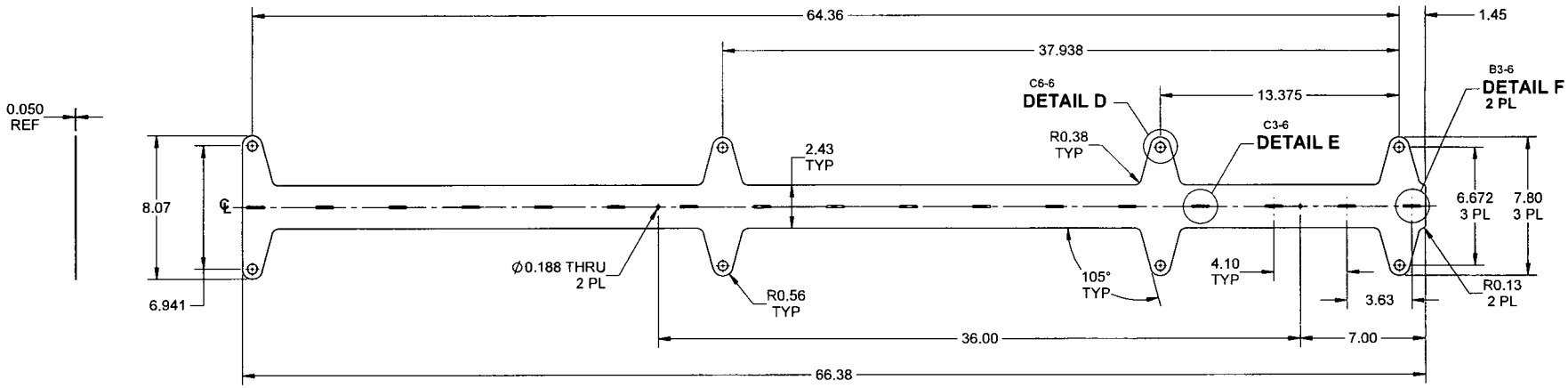
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

w/o 70107



D4406-1 PLATE
(MAKE FROM D4406-1F)



D4406-1F FLAT PATTERN

PRELIMINARY ISSUE

RF 11.05.27

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 2.33 lbs

DESIGN	RF	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4406	REV. PA2
MFG. APPR.			SHEET 4 OF 6
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.			
DATE	11.05.27		

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W/O:		WORK ORDER CHANGES					
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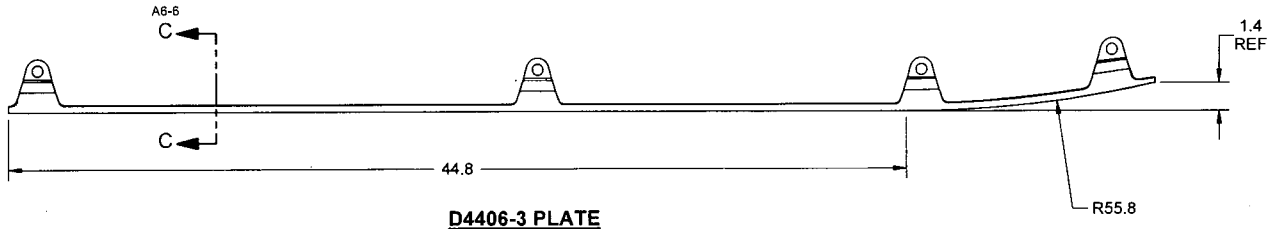
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

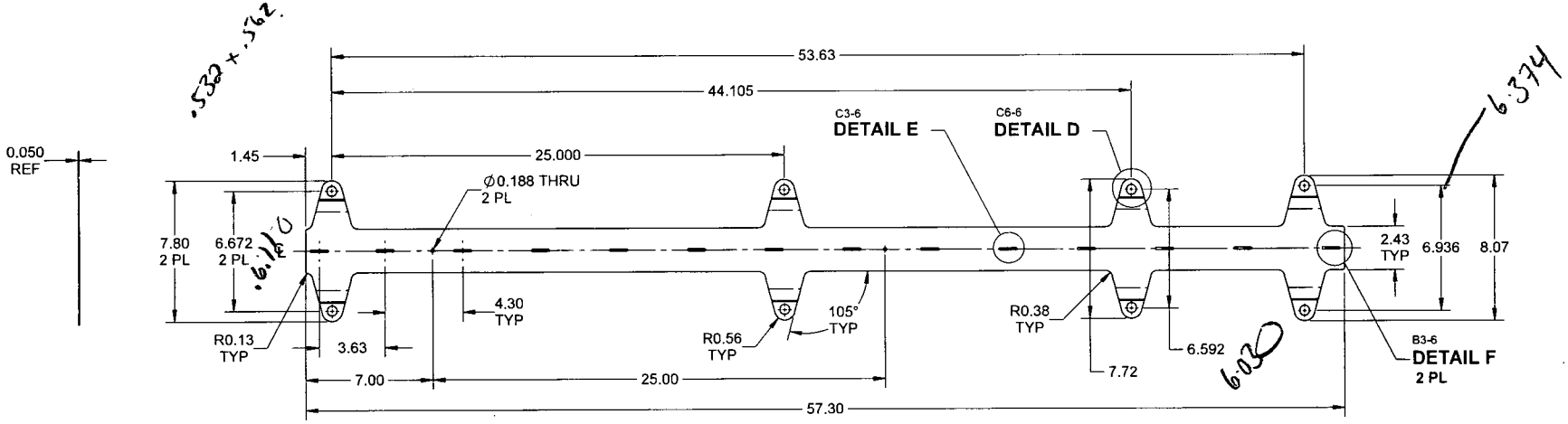
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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

c/o 70407



D4406-3 PLATE
(MAKE FROM D4403-3F)



D4406-3F FLAT PATTERN

PRELIMINARY ISSUE

~~PI~~ 11.05.27

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 2.33 lbs

DESIGN	RF	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4406	REV. PA2
MFG. APPR.			SHEET 5 OF 6
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.			
DATE	11.05.27		

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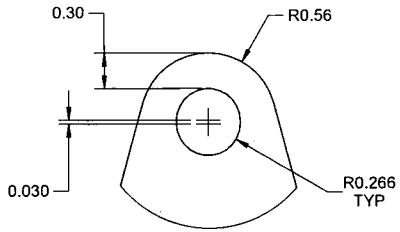
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

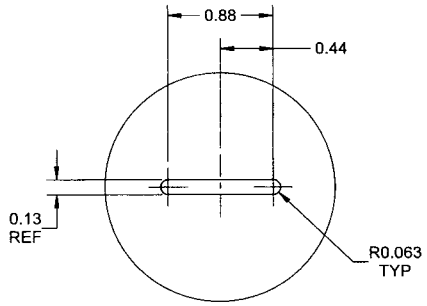
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

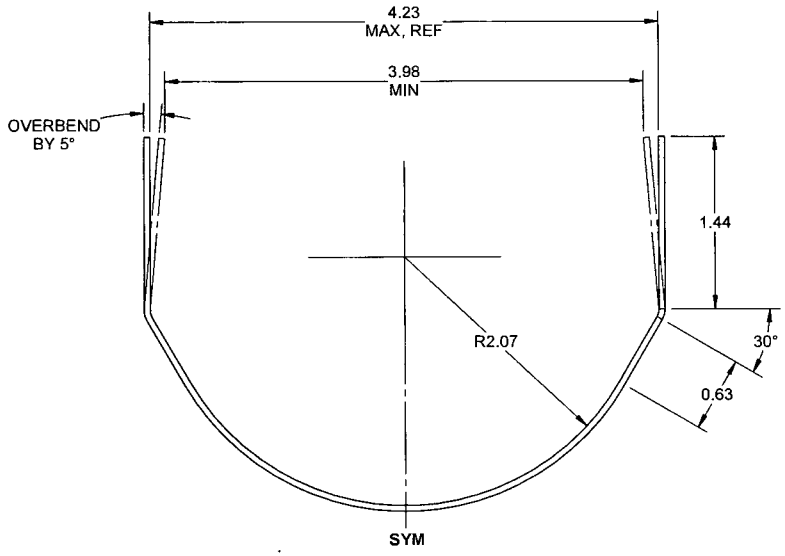


DETAIL D C3-4
SLOT DETAIL TYP C4-5
SCALE 6X

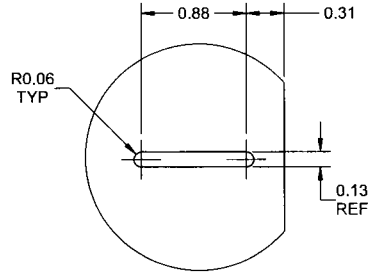


DETAIL E C2-4
SLOT DETAIL TYP C4-5
SCALE 6X

u/o 70407



DETAIL C D2-4
DETAIL TYP D6-5
SCALE 6X



DETAIL F C1-4
SLOT DETAIL TYP B1-5
SCALE 6X

PRELIMINARY ISSUE

11.05.27

DESIGN	RF	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4406	REV. PA2
MFG. APPR.			SHEET 6 OF 6
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries